

Work Order ID 141490-2

Friday, February 05, 2016 8:03:49 AM

Page 1

Item ID: 646.3301

Revision ID:

Item Name: Upper Cutter Assy

Start Date: 2/11/2016

Start Qty: 5.00

Required Date: 2/11/2016

Req'd Qty: 5.00

Reference:

4/8/16

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: FEB 08 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

646.3300

NC3

110

Pick Kit

0.00

110

Packaging

Memo

0.01

Packaging

2x 16/24/12

DAS
36
9-89

120

120

0.00

Small Fab

Memo

0.05

Small Fab

TWO fastener must be install finger-tight (see note 9)

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.

A/R RTV LOCTITE 598: 142524
exp. date: 17/09

2x 16/24/12

DAS
36
9-89

Work Order ID 141490

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141490

Page 2

Item ID: 646.3301

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Upper Cutter Assy

Stop ***NS2***

Start Date: 2/11/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 2/11/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.01							DAS 38 9-89
Quality Control									APR 12 2016
140	Identify as per dwg & Stock Location: CCK018	0.00							
140									
Packaging	Memo	0.00							2 MJS 16-04-14
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							MJS APR 14 2016
Quality Control									

MJS APR 14 2016

Picklist Print

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Page 1

Work Order ID: 141490

141490

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 2/11/2016

Required Date: 2/11/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM
REV:B 15.01.07 AS PER DWG NC3 DD VERF:JLM IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3310 *646.3310* LH Half - Upper Cutter Assembly		Manufactured	No			110	Each	5.0000	1	5			DAS 8-09
Location Loc Qty Loc Code													
CCK022 5													
136232 1													
136656 4													
646.3311 *646.3311* RH Half - Upper Cutter Assembly		Manufactured	No			110	Each	3.0000	1	5			DAS 8-09
Location Loc Qty Loc Code													
CCK022 3													
136146 3													
646.3312 *646.3312* Center Plate		Manufactured	No			110	Each	6.0000	1	5			DAS 8-09
Location Loc Qty Loc Code													
cck103 6													
136728 6													
646.3313 *646.3313* Upper Guide		Manufactured	No			110	Each	0.0000	1	5			DAS 8-09
Location Loc Qty Loc Code													
6													

MAR 23 2016

Picklist Print

Friday, February 05, 2016 8:03:54 AM

Page 2

Work Order ID: 141490

141490

Parent Item: 646.3301

646 3301

Parent Item Name: Upper Cutter Assy

Start Date: 2/11/2016

Required Date: 2/11/2016

Start Qty: 5.00

Required Qty: 5.00

646.3314 Manufactured No

110 Each 7.0000 1 5

646 3314 *P*

Blade

141083

*DAS
3-85*

Location

Loc Qty

Loc Code

cck103

7

136245

7

646.3315 Manufactured No

110 Each 5.0000 1 5

646 3315 *P*

Blade

1410576

*DAS
3-85*

Location

Loc Qty

Loc Code

cck103

5

136663

5

646.3316 Manufactured No

110 Each 16.0000 1 5

646 3316

Blade

161324

Location

Loc Qty

Loc Code

cck103

16

136513

16

NAS1149FN832P Purchased No

110 Each 3,171.000 36 180

NAS1149FN832P

Washer

*DAS
MAR 23 2016*

*DAS
36
9-89*

Location

Loc Qty

Loc Code

GA

1661

M133316

16

M133769

1645

ST262

1510

M133709

1510

72

16/04/05

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Shop Packet Print

Page 2

Picklist Print

Friday, February 05, 2016 8:03:54 AM

Page 3

Work Order ID: 141490

Parent Item: 646.3301

Parent Item Name: Upper Cutter Assy

141490

646.3301

Start Date: 2/11/2016

Required Date: 2/11/2016

Start Qty: 5.00

Required Qty: 5.00

MS21042L08

Purchased

No

110

Each

1,790.000

18

90

MS21042L08

Nut

DAS
36
9-89

16/04/08

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

275

m133134

3

m134063

272

OVER007

500

m134063

500

ST303

914

m133922

914

36

NAS1149F0332P

Purchased

No

110

Each

3,524.000

6

30

NAS1149F0332P

Washer

DAS
36
9-89

16/04/08

Location

Loc Qty

Loc Code

GA

396

m133709

396

ST260a

1500

m134134

1500

ST262

1628

m133938

128

m134055

1500

12

Picklist Print

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Work Order ID: 141490

141490

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 2/11/2016

Required Date: 2/11/2016

Start Qty: 5.00

Required Qty: 5.00

AN3-12A

Purchased

No

110

Each

77.0000

2

10

AN3-12A

Bolt

Location

Loc Qty

Loc Code

GA

2

m129682

2

ST349

75

m133064

16

m133234

59

MS21042L3

Purchased

No

110

Each

2,319.000

3

15

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

163

m133790

163

GA

168

m133790

168

ST304

1988

m133790

2

m134039

1986

DAS
36
9-89
16/04/05
M134360
6x

Picklist Print

Friday, February 05, 2016 8:03:54 AM

Page 5

Work Order ID: 141490

141490

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 2/11/2016

Required Date: 2/11/2016

Start Qty: 5.00

Required Qty: 5.00

MS27039-08-19

Purchased

No

110

Each

1,057.000

18

90

MS27039-08-19

Screw

DAS

36

9-89

16/04/05

Location

Loc Qty

Loc Code

CCK06

200

m134142

200

GA

106

m132930

84

m133077

22

over006

668

m133483

68

m134063

600

36

ST277

83

m133769

83

AN3-14A

Purchased

No

110

Each

114.0000

1

5

AN3-14A

Bolt

DAS

36

9-89

16/04/05

Location

Loc Qty

Loc Code

over003

50

m133992

50

ST349

64

m133363

24

m134167

40

5

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04765

SHEET 1 OF 1

DWG NO. 646.3300

REV: NC

PREPARED BY J. SOTO

DATE: 12/08/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY:

ENGR. *[Signature]*

MFG. *[Signature]*

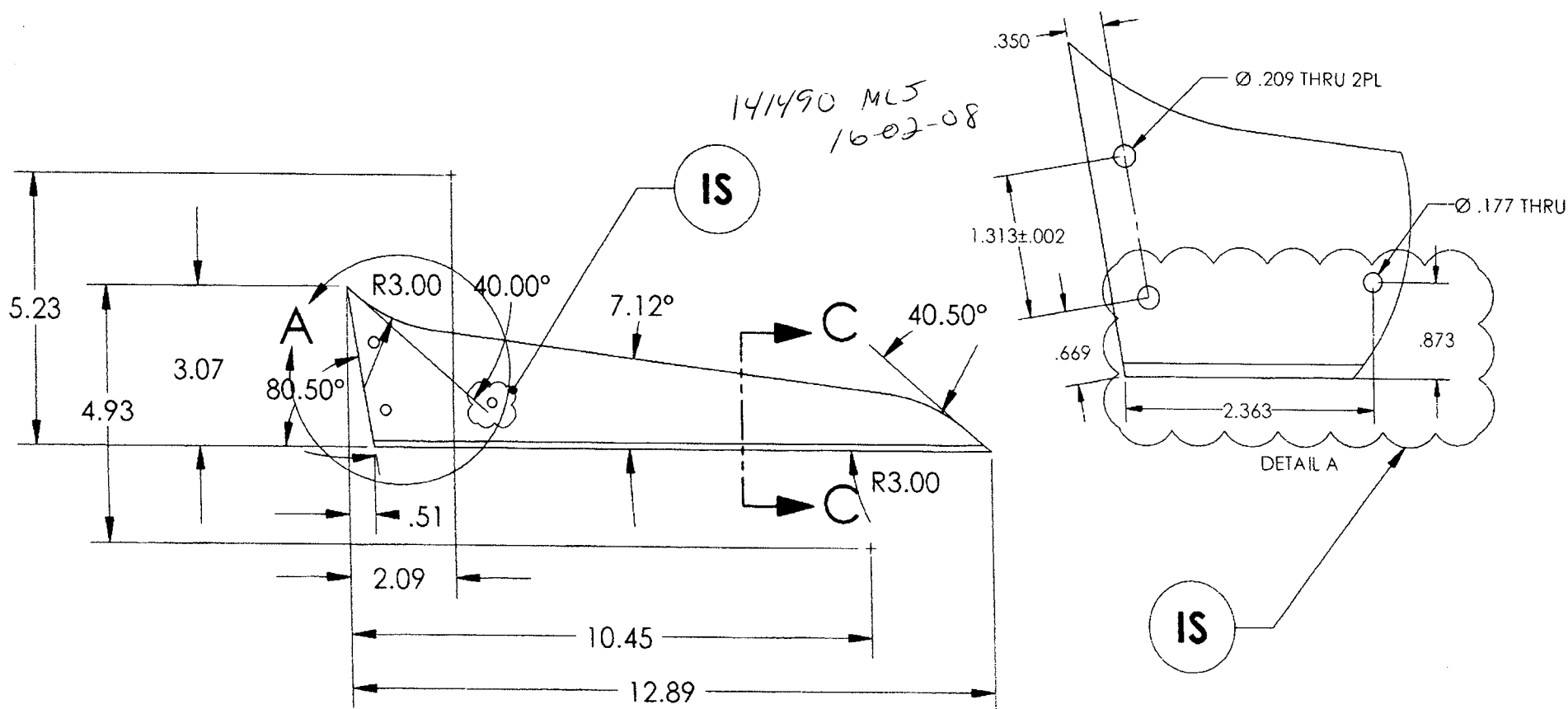
QC *[Signature]*

EFF. NEXT ORDER

TRANSACTION CODES (TC):
 A-ADD C-CREATE
 R-REVISE D-DELETE

REASON: ADDED HOLE DIMENSION TO 646.3313.

SHEET 5 IS:



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03724

SHEET 1 OF 1

DWG NO. 646.3300

REV: N/C

PREPARED
BY B. PETERS

DATE: 12/05/12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

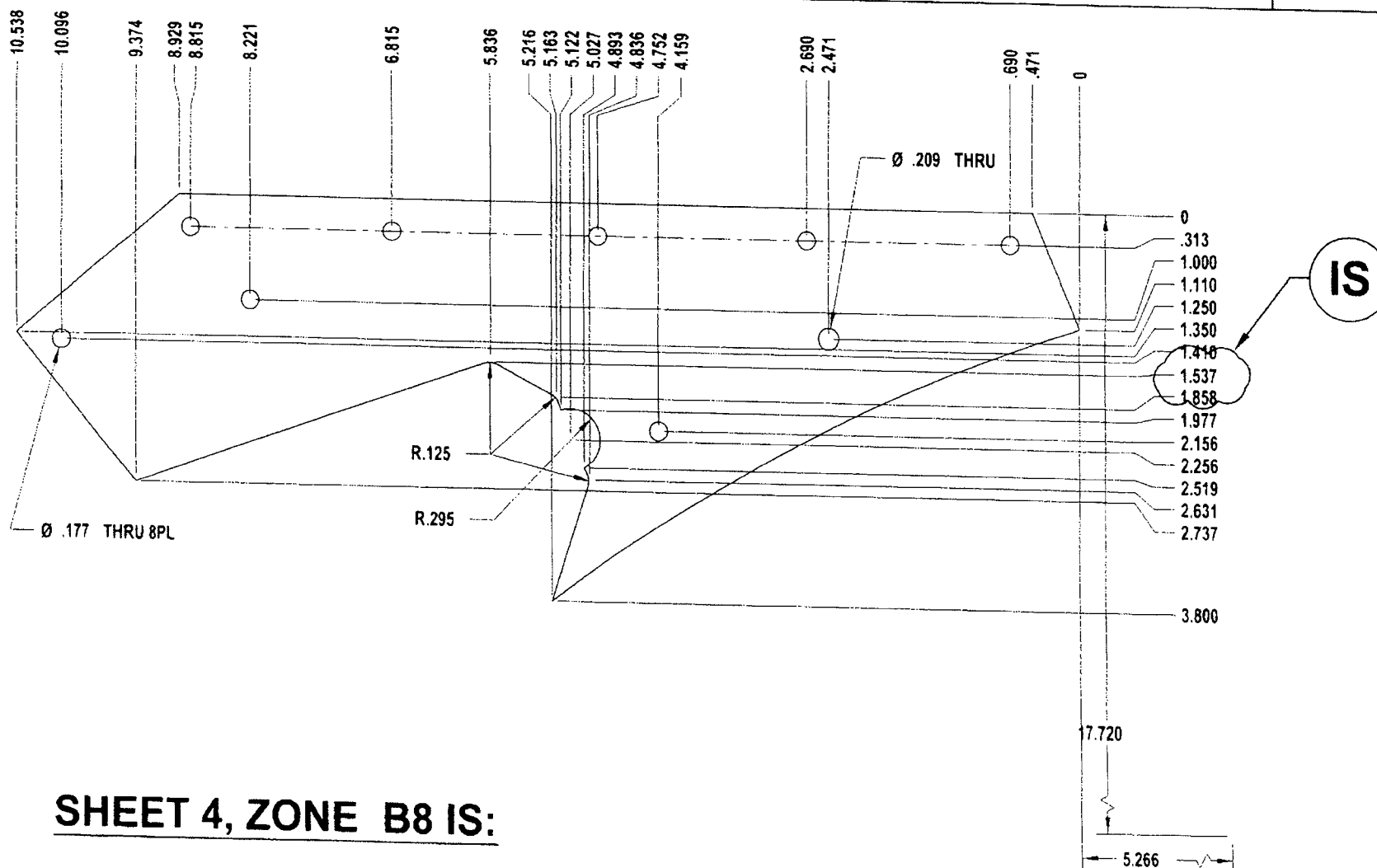
TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON:

REVISED ORDINATE DIMENSION.

ECR:

D-12-025



SHEET 4, ZONE B8 IS:

DOCUMENTS EFFECTED:

☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

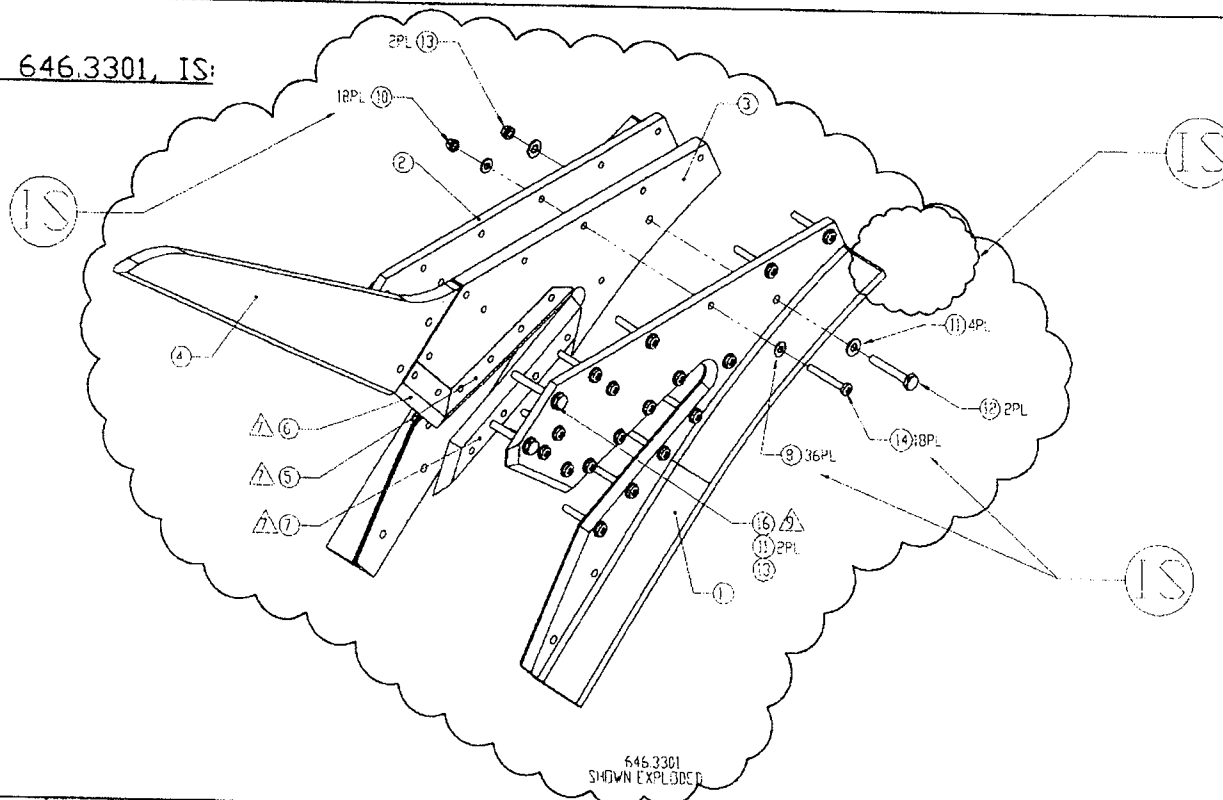
DER REVIEW REQUIRED
☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 02196		SHEET 1 OF 2	
DWG NO. 646.3300	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
DWG TITLE: UPPER CUTTER ASSY		EFFECT ON DWG ☐ INC. ☒ UNINC.	
APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER
REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS			

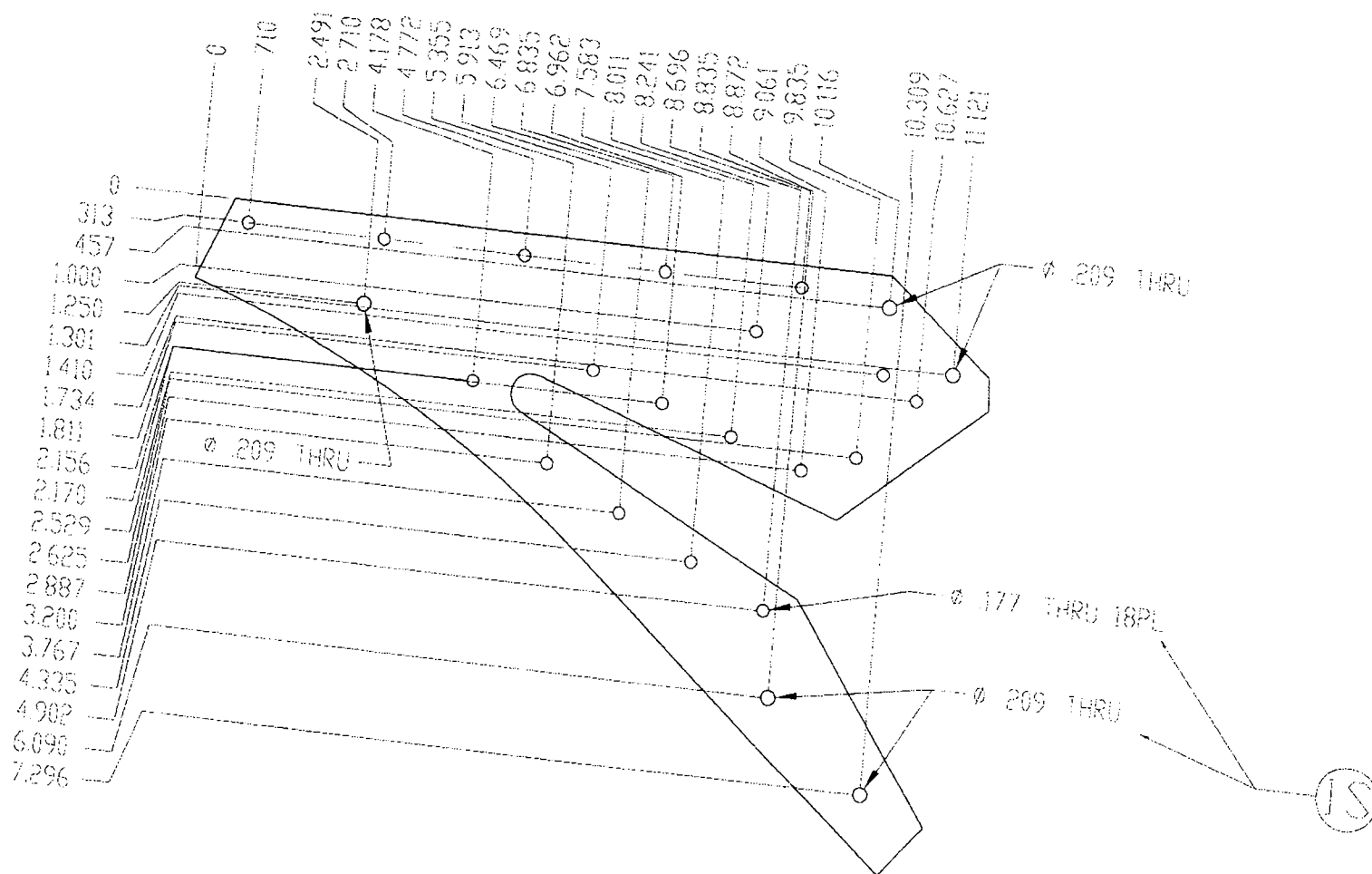
TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

SHEET 1, VIEW 646.3301, IS:



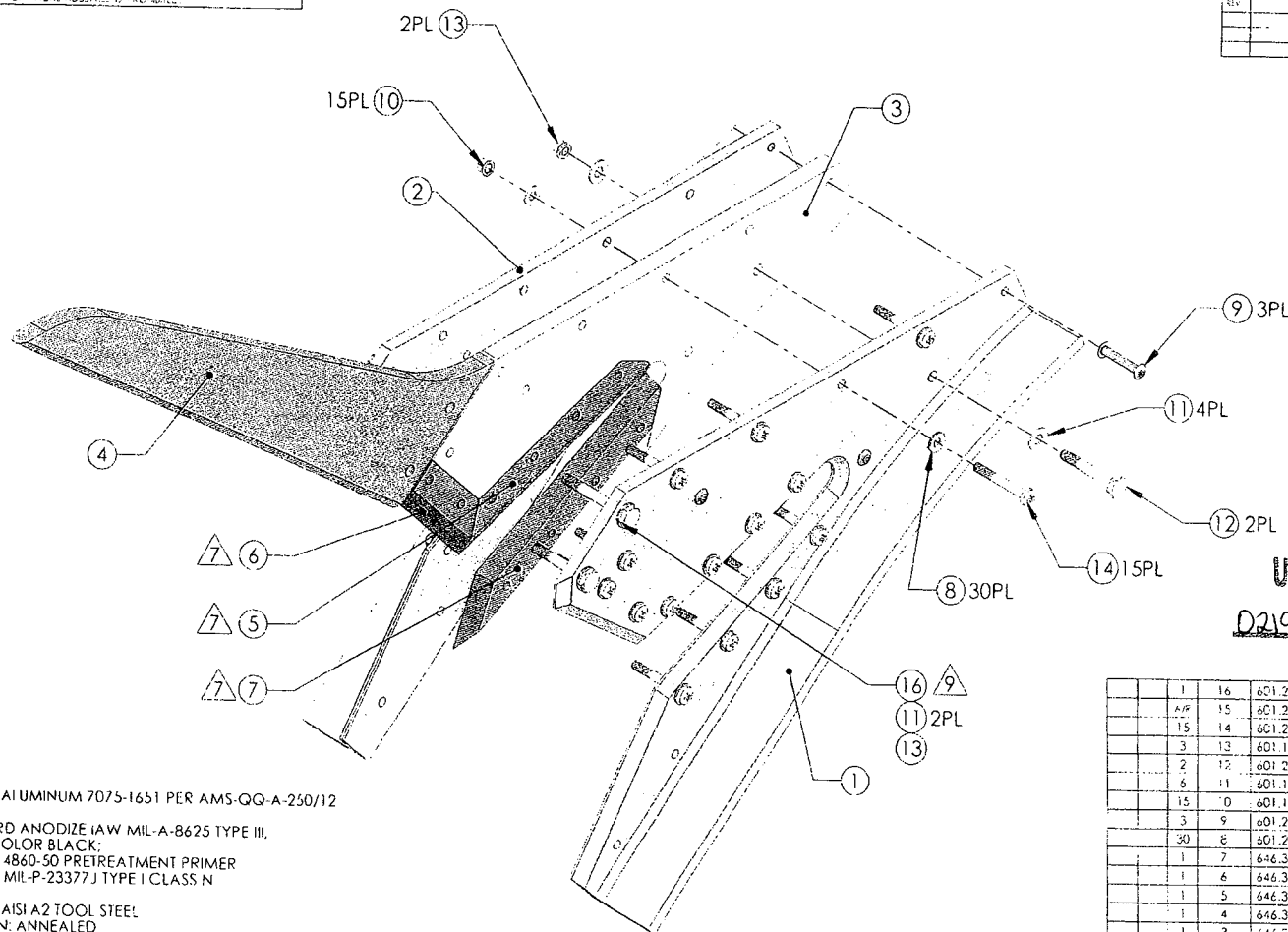
14	R	601.2765		18	SCREW	MS27039-0819
10	R	601.1541		18	LOCKNUT	MS21042L08
9	D	601.2766		3	RIVET	MS20470AD5-18
8	R	601.2764		36	WASHER	NAS1149FN832P
				3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:						
☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM						CHANGE CATEGORY ☐ MAJOR ☒ MINOR
						DER REVIEW REQUIRED ☐ YES ☒ NO

SHEET 3, SECTION VIEW A-A, IS:



PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
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NOTES:

- 1 MATERIAL: ALUMINUM 7075-1651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377 J TYPE I CLASS N
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377 J TYPE I CLASS N

5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED

6. IDENTIFY JAW MPP-120

7. APPLY F/N 15 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5, 6 & 7 UPON ASSEMBLY
8. CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
9. INSTALL FASTENER FINGER-TIGHT

646.3301
SHOWN EXPLODED

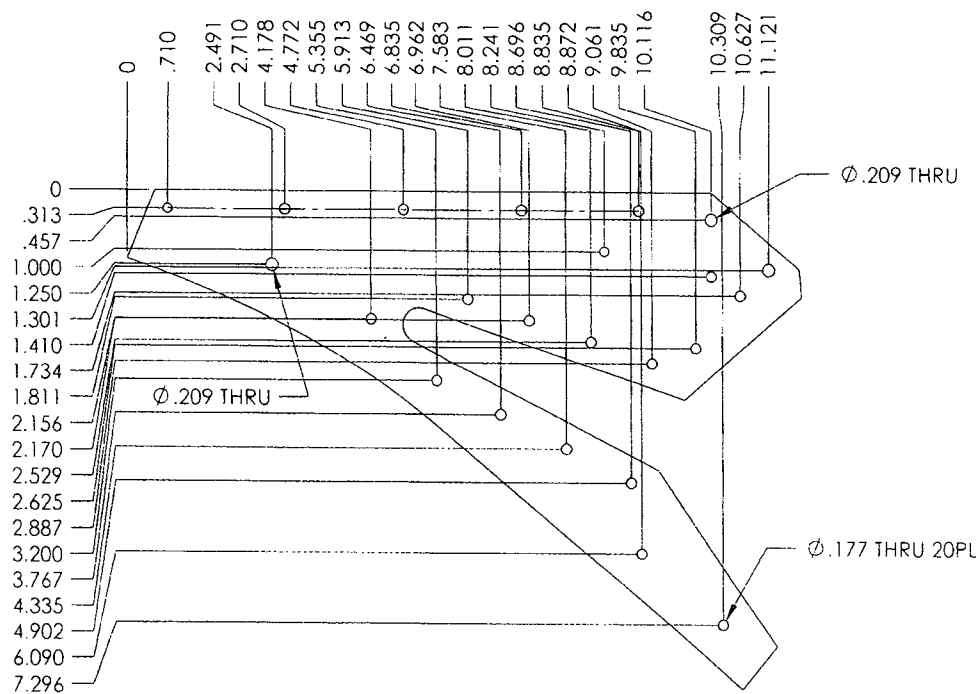
[illegible]

UNINCORPORATED ECN(S)

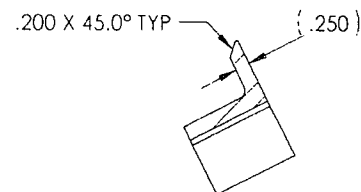
02196, 03724, 04765

[illegible]

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WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED



SECTION A-A

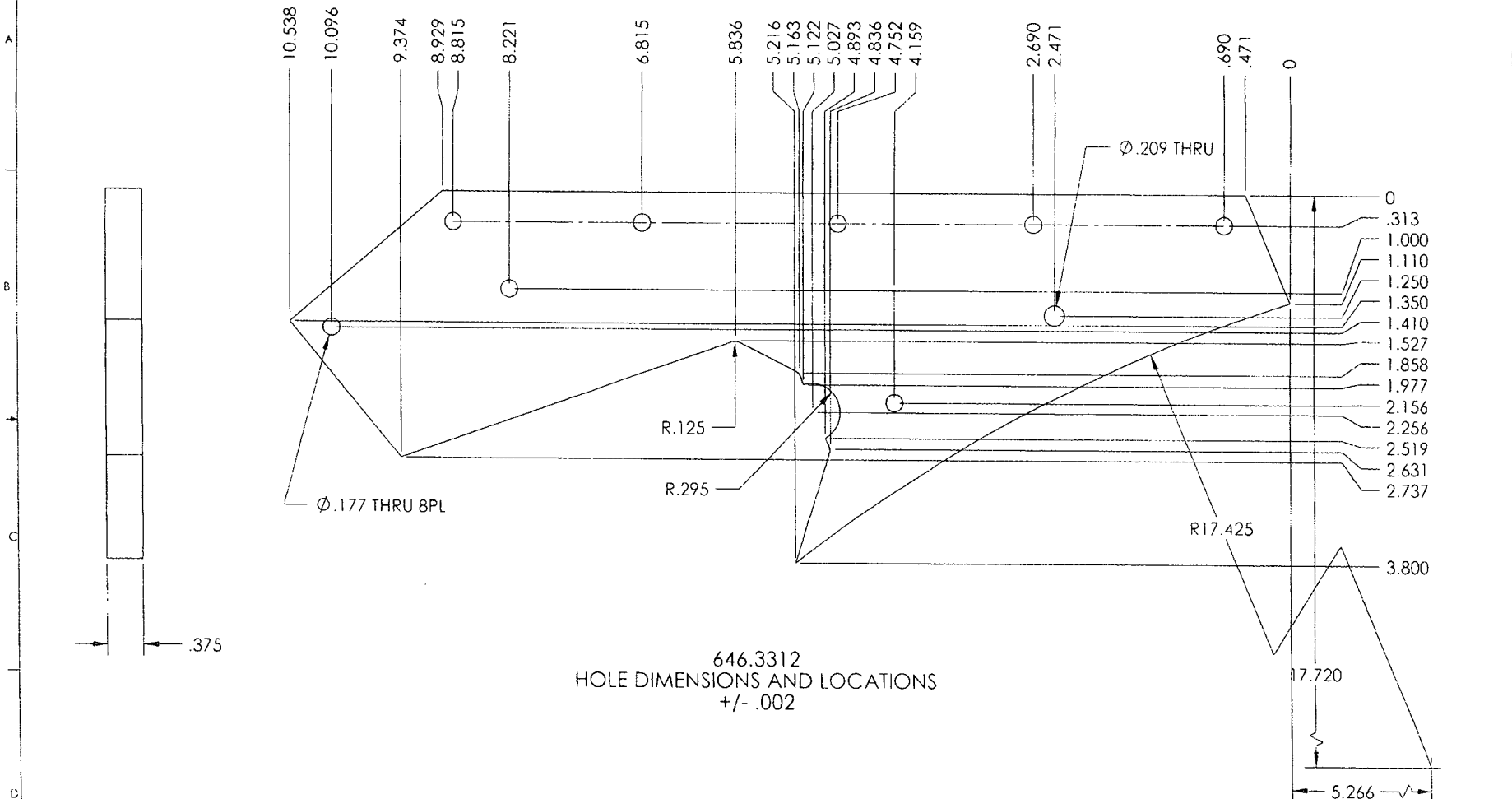


SECTION B-B

C/C: DATE		APICAL INDUSTRIES	
C/C: DATE		2600 TIAPLE HEIGHTS DR.	
C/C: DATE		OCEANSIDE, CA 92036 3512 (760) 724 5300	
C/C: DATE		UPPER CUTTER ASSY	
C/C: DATE		646.3300	
C/C: DATE		SCALE: NONE	
C/C: DATE		SHEET: 3 OF 6	

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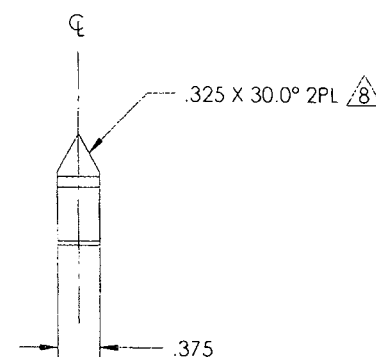
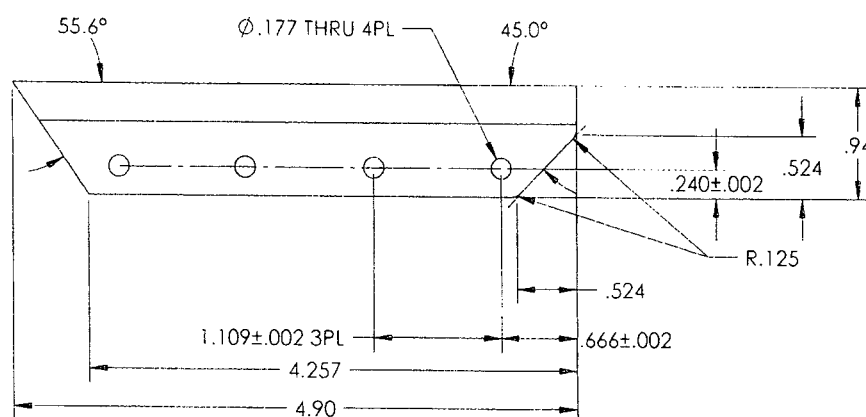
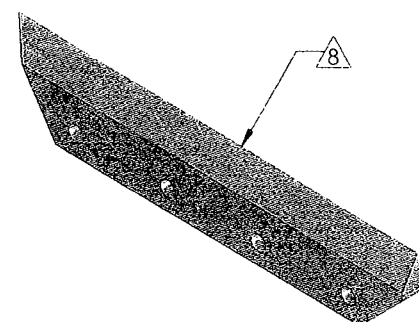
REV.	DESCRIPTION	DATE



646.3312
HOLE DIMENSIONS AND LOCATIONS
+/- .002

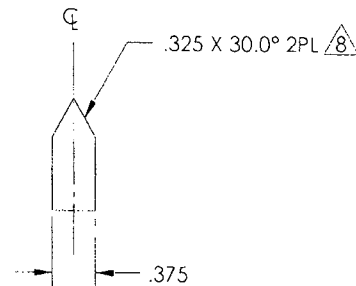
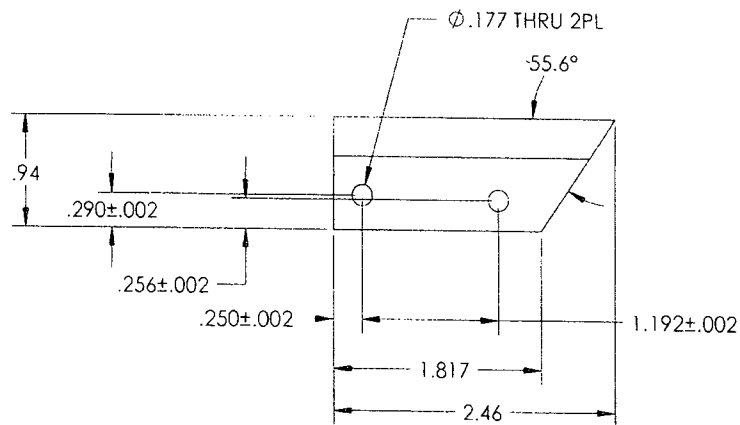
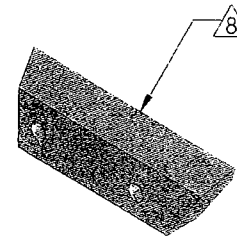
DESIGNED BY: [blank] CHECKED BY: [blank] DRAWN BY: [blank] APPROVED BY: [blank] DATE: [blank]	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300
PART NAME: 646.3300 SCALE: NONE	SHEET: 4 OF 8

REVISED		DATE	APPROVAL
FLY	DESCRIPTION		

[illegible]

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REV.	DESCRIPTION	DATE	APPROVED



646.3315

PREPARED BY DATE DRAWN BY DATE CHECKED BY DATE	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
UPPER CUTTER ASSY DATE SCALE: NONE	646.3300 1 OF 1 1 SHEET 2 OF 8

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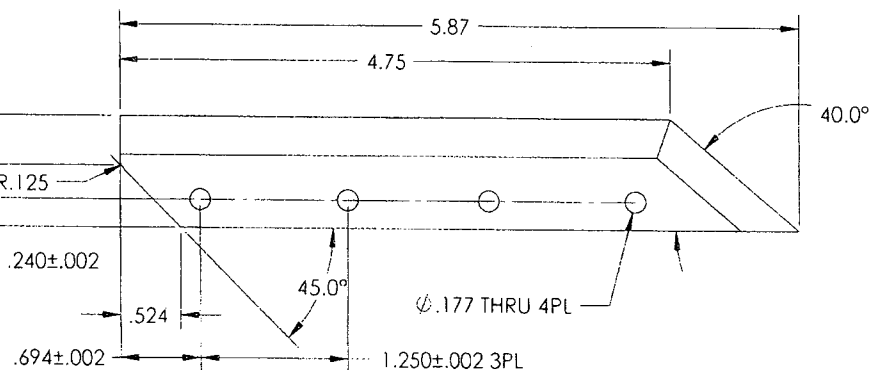
REV	DESCRIPTION	DATE	APPROVED

A

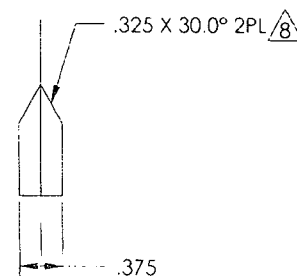
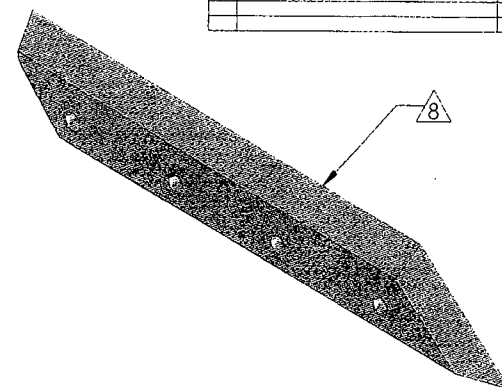
B

C

D



646.3316



OCEAN (DATE)		APICAL INDUSTRIES	
DESIGNED BY	DATE	2608 TEMPLE HEIGHTS DR.	
DRAWN BY	DATE	OCEANSIDE, CA. 92056-5512 (760)724-5300	
CHECKED BY	DATE	UPPER CUTTER ASSY	
APPROVED BY	DATE	646.3300	
SCALE	NONE	SHEET E OF B	